

Work Order ID 51906



Page 1

Wednesday, September 09, 2009 11:10:48 A

Item ID:	D3793-1	6V	Accept		Setup	Start	
Revision ID:	A					Stop	
Item Name:	Wearshoe						
Start Date:	9/10/2009	Start Qty:	12.00		Cust Item ID:		
Required Date:	9/18/2009	Req'd Qty:	12.00		Customer:		
Reference:							

Approvals:	Process Plan:	<u>PLM</u>	Date:	<u>09-9-09</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100

0.00



FLOW WATER JET

Waterjet

304

Memo

0.00

FLOW CNC Waterjet

.046

1-Cut as per Dwg D3793 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

13 9-10-2

(16)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

14 9-10-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 80810105

(16)

f

Work Order ID 51906



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Wednesday, September 09, 2009 11:10:48 A

Item ID: D3793-1	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Wearshoe					
Start Date: 9/10/2009	Start Qty: 12.00		Cust Item ID:		
Required Date: 9/18/2009	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				16	0		
Brake NC	Memo 1-Deburr if necessary □ 2-Form on Brake as per Dwg D3793 using Jigs □ 3-Form Joggle on brake using Jig as per Dwg D3793	0.00							SB 09/10/06
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				16	1		
150 Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 8:00 FINISH TIME: 8:30	0.00							OK 09-10-7

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Item ID: D3793-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearshoe

Start Date: 9/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

=> JJ 09/10/09

(X16)

Ø

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: F12-18

0.00

=> MJ 09/10/09

X16

Ø

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

09/10/09 JJ

QC

Memo

0.00

Quality Control

mk 09-10-09

Picklist Print

Page 1

Wednesday, September 09, 2009 11:10:47 AM

Work Order ID: 51906



Parent Item: D3793-1RevA



Parent Item Name: Wearshoe

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	245.8640	7.4552	9.9402		
304/316 .040 Sheet											29-10-2	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

245.8640474

110076

31.73

111571

22.1340474

112567

192

112567

DART AEROSPACE LTD		Work Order: 51906
Description: Wearshoe		Part Number: D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	*			
0.300 x 0.300	+/-0.010	.304 x .307	*			
1.885	+/-0.010	1.884	*			
2.000	+/-0.010	2.000	*			
5.00	+/-0.030	5.00	*			
8.00	+/-0.030	8.00	*			
14.00	+/-0.030	14.00	*			
20.00	+/-0.030	20.00	*			
14.066	+/-0.010	14.066	✓			
18.983	+/-0.010	18.983	*			
23.900	+/-0.010	23.900	*			
27.400	+/-0.010	27.400	*			
29.400	+/-0.010	29.400	*			
32.900	+/-0.010	32.900	*			
0.040	+/-0.010	.036	*			

Measured by: JB
Date: 9-10-0

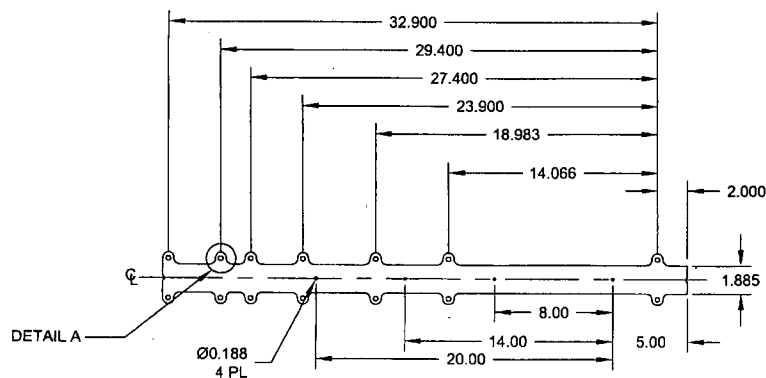
Audited by: S
Date: 09/10/05

Prototype Approval:	N/A
Date:	N/A

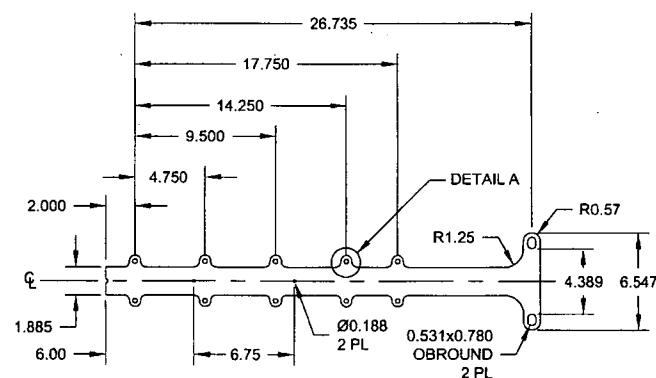
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	JB

SHOP COPY

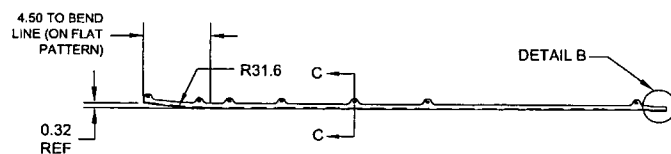
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WITHOUT NOTICE
WORK ORDER
NO. 51906



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

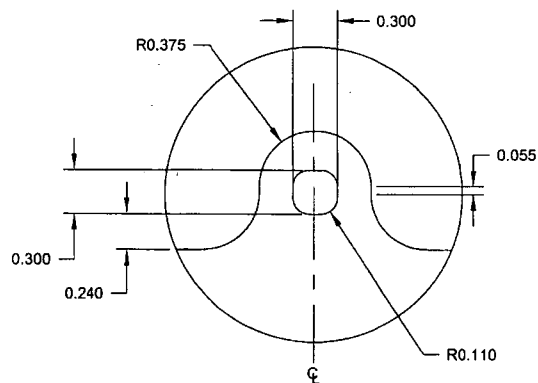
RELEASED
08.05.14

NOTES:

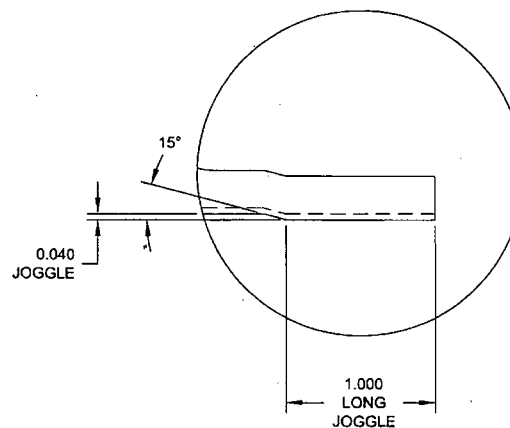
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE	PH	08.05.14
REV.		DESCRIPTION	BY DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3793 TITLE WEARSHOE COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	REV. A
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APPROVED			SCALE
DE APPR.	DA		NTS
DATE	08.05.14		

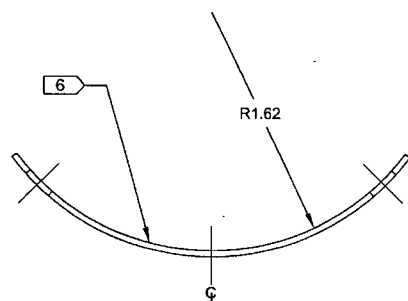
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

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MFG. APPR.	IS	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
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8 7 6 5 4 3 2 1